

# PROTOTYPE

**Work Order ID 70892**

Thursday, June 16, 2011 2:32:24 PM

Page 1

Item ID: D4055-5

Accept

Revision ID:

Item Name: Tank Upper Cut Out

Start Date: 6/16/2011 Start Qty: 1.00

Required Date: 6/22/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *u*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4055

B

0.00

0.00

0.00

0.00

0.00

0.00

100



Purchasing

Purchasing

Memo

Issue P/O: *u*

Purchase part as per Dwg D4055

Possible Supplier: GF1

Material release note required

101



Waterjet

FLOW CNC Waterjet

*6061.063*

Memo

cut as per drwg D4055 Rev.B

102



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

# SCRAP

*Scrap*  
*cut + cut properly*  
*for bend*  
*B11-6-21*  
*u 6-27-15*

*B11-6-21*

**Work Order ID 70892**

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Thursday, June 16, 2011 2:32:24 PM

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/16/21

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

QC 6

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

**Work Order ID 70892**

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Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Thursday, June 16, 2011 2:32:22 PM

Page 1

Work Order ID: 70892



Parent Item: D4055-5



Parent Item Name: Tank Upper Cut Out

Start Date: 6/16/2011

Required Date: 6/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

251.6700

0.16



1311-6-21

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

251.67

116308

29

117285

222.67

116308

①

DART AEROSPACE LTD	Work Order: 70892
Description: TANK UPPER CUT OUT	Part Number: D4055-5
Inspection Dwg: D4055-6, Rev: B	Page 1 of 1

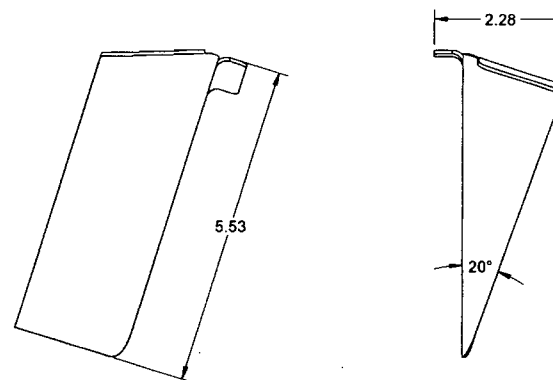
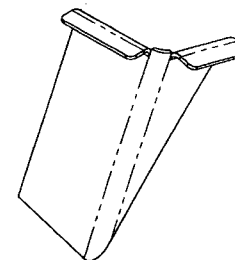
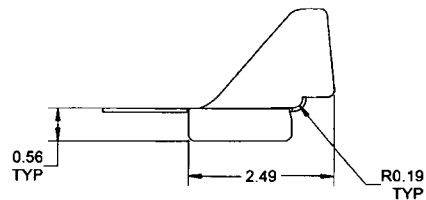
## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <b>RB</b>	Audited by: <b>S</b>	Prototype Approval:
Date: <b>11-6-21</b>	Date: <b>11/04/21</b>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



# **D4055-5 UPPER CUT OUT**

**RELEASED**  
2011-05-30  
NW

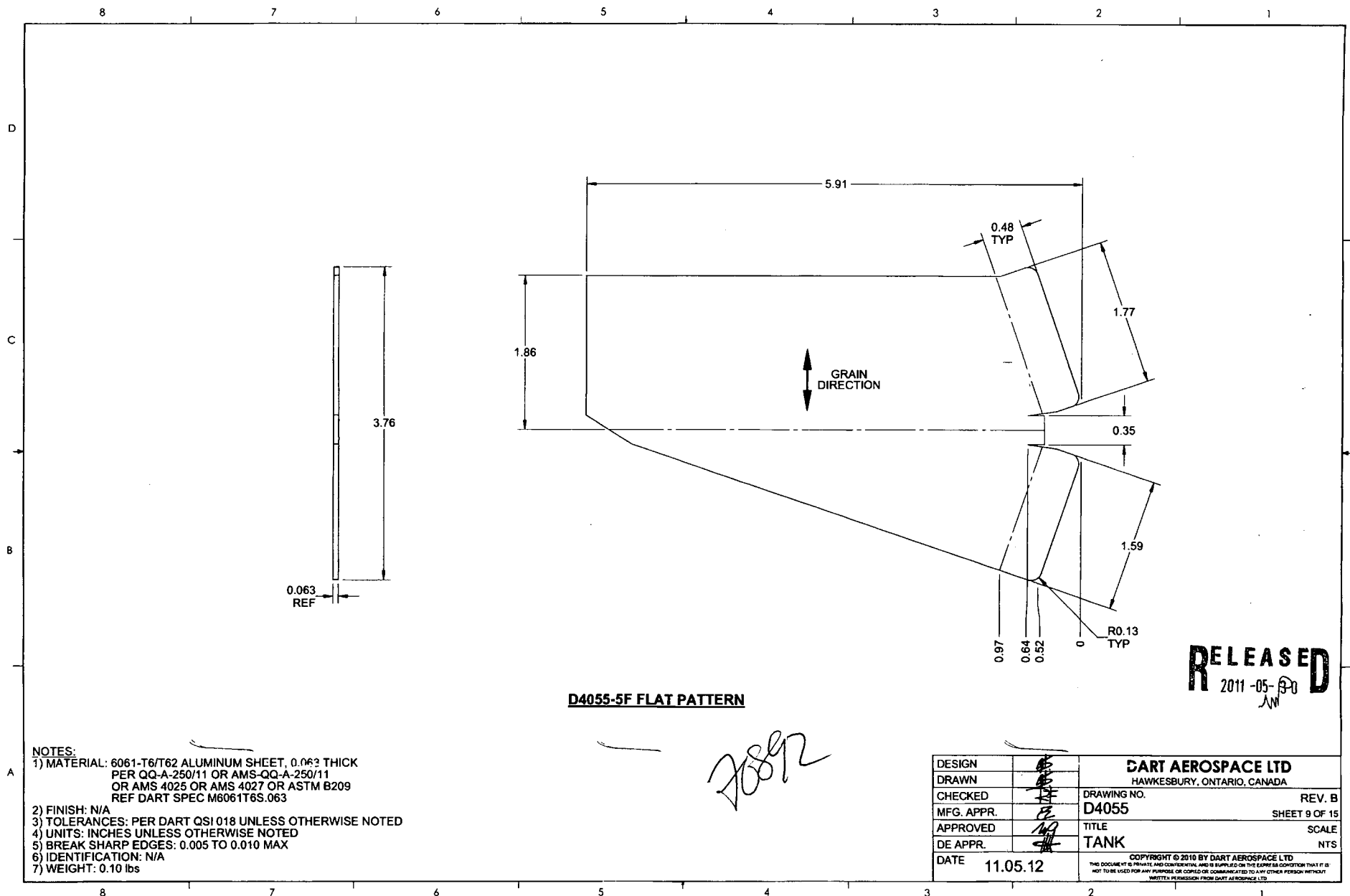
## **NOTES:**

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs









*708912*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4055</b>	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
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**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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